



Work Order ID 107461

\*107461\*

Page 2

September-24-13 2:16:09 PM

Item ID: D3186-4

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Spacepod Door, RH

Start Date: 9/24/13 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 9/27/13 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

*[Signature]* / Dm 13/10/07

\*130\*

QC

Quality Control

Memo

0.00

*MF* 13/10/07

# Picklist Print

September-24-13 2:16:09 PM

Page 1

/1

Work Order ID:	107461	Start Date:	9/24/13	Required Date:	9/27/13
Parent Item:	D3186-4	Start Qty:	1.00	Required Qty:	1.00
Parent Item Name:	Spacepod Door, RH				
Comments:	IPP Rev:A New Issue 07-01-11 EC IPP rev.B revD 07.03.07 ec door before drilling DD verf:EC	IPP Rev:C 10-08-11 added trim			

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M Spacepod Door RH		Manufactured	No			100	Each	1.0000	1	1		W 13-09-24	

Location	Loc Qty	Loc Code
CA	1	
95160	1	

75465 95160

8 7 6 5 4 3 2 1

D

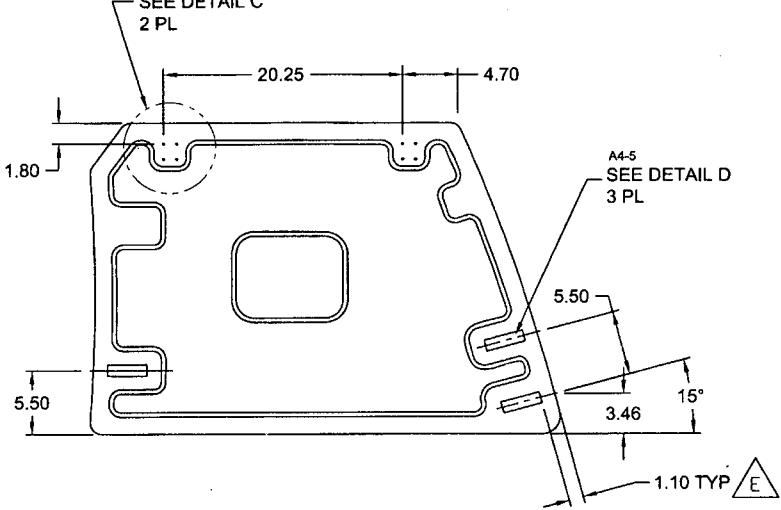
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C

C

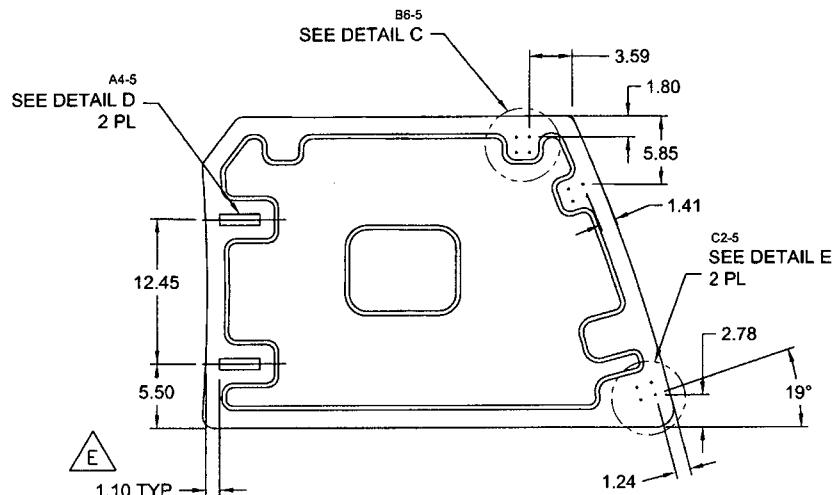
B

B



D3186-1 SPACEPOD DOOR, LH  
MAKE FROM D3186-1M

NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: N/A

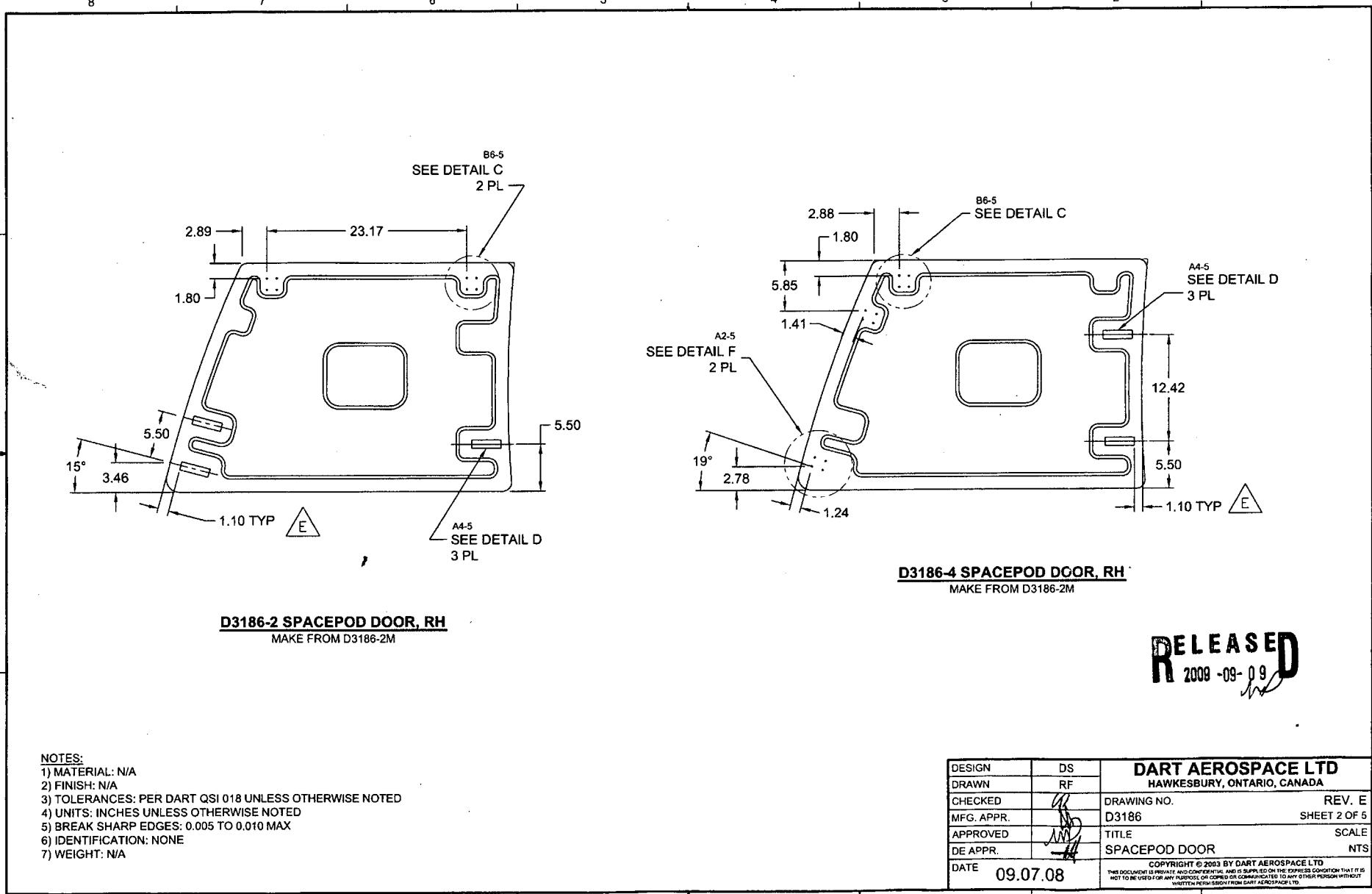


D3186-3 SPACEPOD DOOR, LH  
MAKE FROM D3186-1M

**RELEASED**  
2009-09-09

*Mo. 1/2/09*

E	DRAWING UPDATED TO CURRENT STANDARDS. 1.10 WAS 0.98 (ZN B5-1, B4-1, B7-2, B1-2); R0.12 WAS 0.125 (ZN B5-5); REF PAR 09-026	RF	09.07.08
D	UPDATE DIMENSIONS	LE	07.02.22
C	REMOVED D0600-XXX LABELS	LE	06.12.13
B	DIMS UPDATED TO MATCH PRODUCT FOAM PATTERN UPDATED D3186-1M-2M-3/4 ADDED	LE	06.09.25
A	NEW ISSUE	CP	03.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>10</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>AS</i>	D3186	SHEET 1 OF 5
APPROVED	<i>AS</i>	TITLE	SCALE
DE APPR.	<i>AS</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



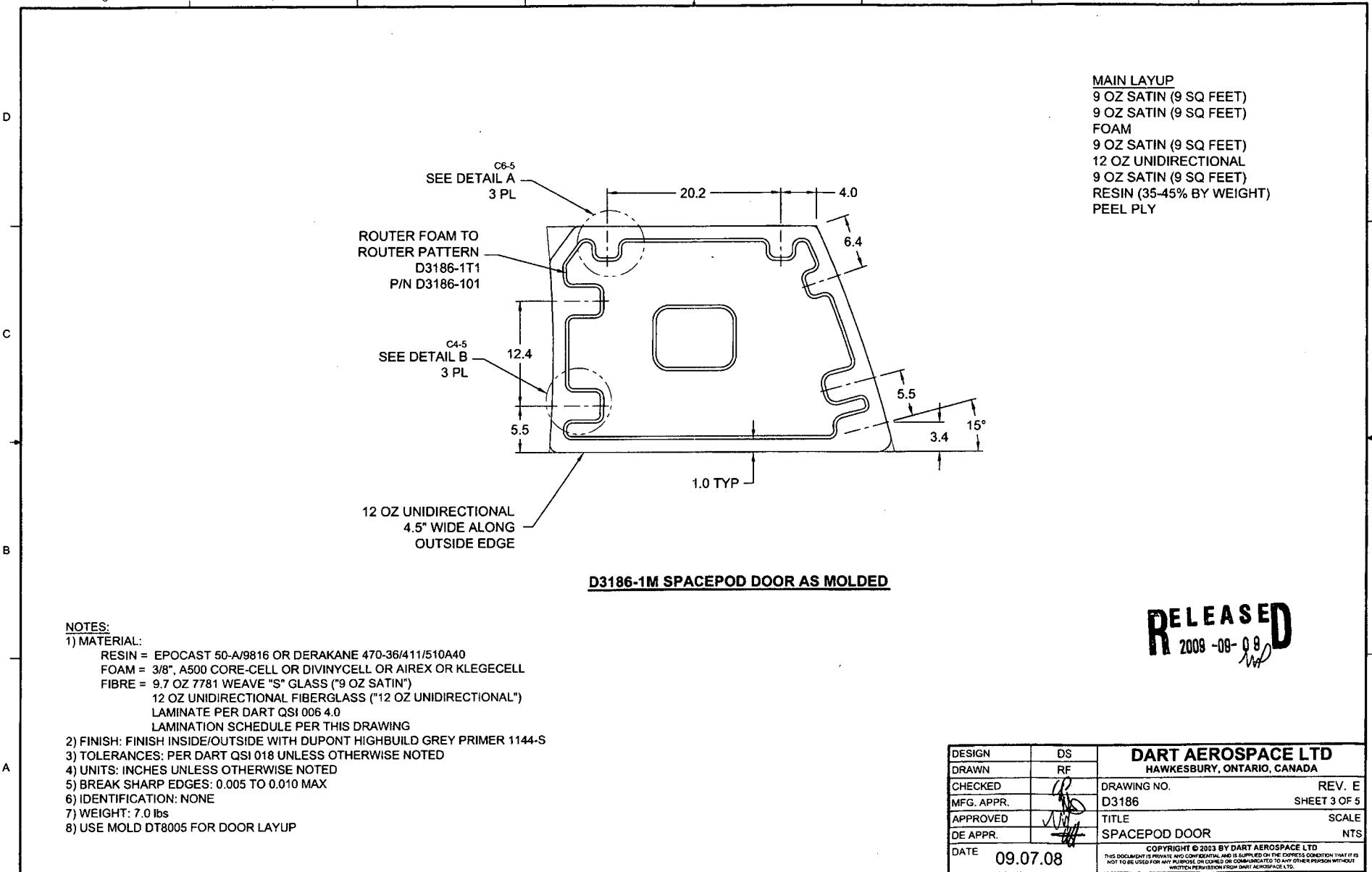
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2009-09-09

DESIGN	DS	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>JK</i>	REV. E
MFG. APPR.	<i>JK</i>	DRAWING NO. D3186 SHEET 2 OF 5
APPROVED	<i>JK</i>	TITLE
DE APPR.	<i>JK</i>	SCALE NTS
DATE	09.07.08	SPACEPOD DOOR

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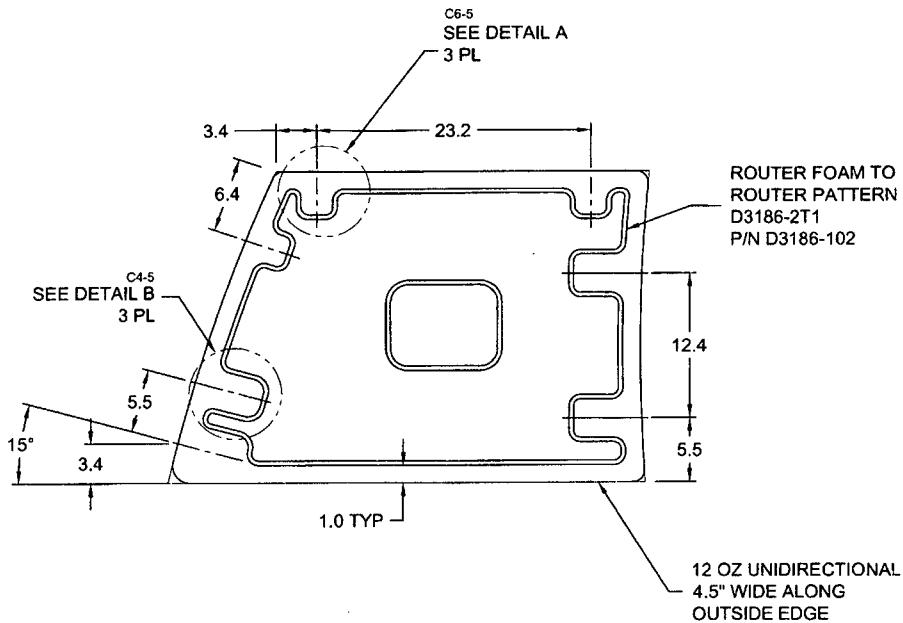
NOTES:  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: N/A

8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1

MAIN LAYUP  
 9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY



NOTES:

- 1) MATERIAL:  
 RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINCELL OR AIREX OR KLEGECCELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0  
 LAMINATION SCHEDULE PER THIS DRAWING
- 2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 7.0 lbs
- 8) USE MOLD DT8006 FOR DOOR LAYUP

D3186-2M SPACEPOD DOOR AS MOLDED

RELEASED  
 2009-09-09  
*[Handwritten Signature]*

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CHECKED	<i>[Signature]</i>	REV. E	
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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8 7 6 5 4 3 2 1

D

D

C

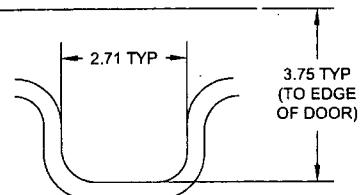
C

B

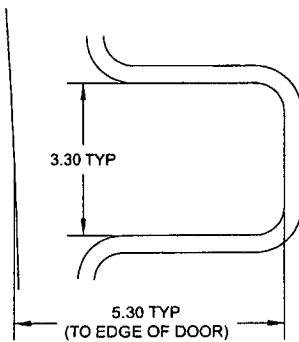
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A

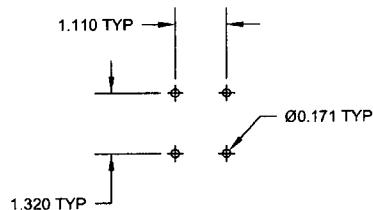
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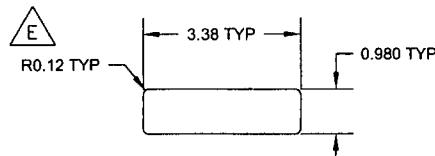
**DETAIL A** D6-3  
SCALE 4X D4-4



**DETAIL B** C6-3  
SCALE 4X C6-4

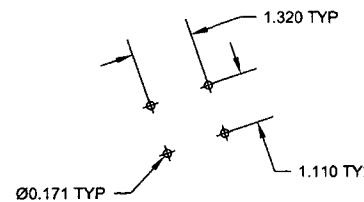


**DETAIL C** D7-1  
D9-1  
SCALE 4X D6-2  
D3-2

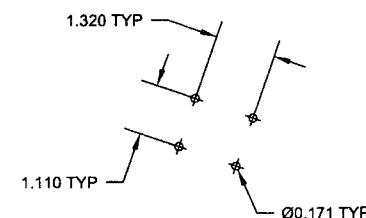


NOTE: ENSURE THAT CUTOUT IS  
PERPENDICULAR TO EDGE OF DOOR

**DETAIL D** C5-1  
D4-1  
SCALE 4X B6-2  
C2-2



**DETAIL E** C1-1  
SCALE 4X



**DETAIL F** C4-2  
SCALE 4X

**RELEASED**  
2009-09-09

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MFG. APPR.		D3186	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
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